

Date: Tuesday, 4/17/2007 3:56:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEAR PLATE
Job Number	: 31919		
Estimate Number	: 11231		
P.O. Number	: <u>N/A</u>	Part Number	: D2348
This Issue	: 4/17/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2348 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: B2
Previous Run	: 27736	Material	: <u>N/A</u>
Written By	: <u>H 07.04.18</u>	Due Date	: 5/20/2007
Checked & Approved By	: <u>H 07.04.18</u>	Qty:	<u>53</u> 50 Um: Each
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: M19326

SAP 07/05/09

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2348
 Dwg Rev: B2
 Prog Rev: B2

SAP 07/05/09

53

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/05/09

53

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAP 07/05/09

53

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1







X 53

Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

M 07/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ QA: N/C Closed: _____ Date: 07/03/05

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/09	2.0	2 part Scrap need to change offset on machine from 0.05 to 0.013	 GS1042	Scrap - destroy replace	SAD 07/05/09	 07/05/09	 GS1042	 07/05/09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 31919

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/09 (53)

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 3741

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

C 07/05/10 (53)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C 7/5/18 (53)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
INSPECT CERTS

0705.23
counted SB

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert

M104192-X

m101634 X13

07/05/23 (53)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

07/05/24
ml (X 53)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/24 (53)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/03/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 31919

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 30

07/15/04

(53)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(53)

Comment: FINAL INSPECTION/W/O RELEASE

07/15/05

Job Completion



Le 07/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31919
Description: Wear Plate		Part Number:	D2348
Inspection Dwg: D2348 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

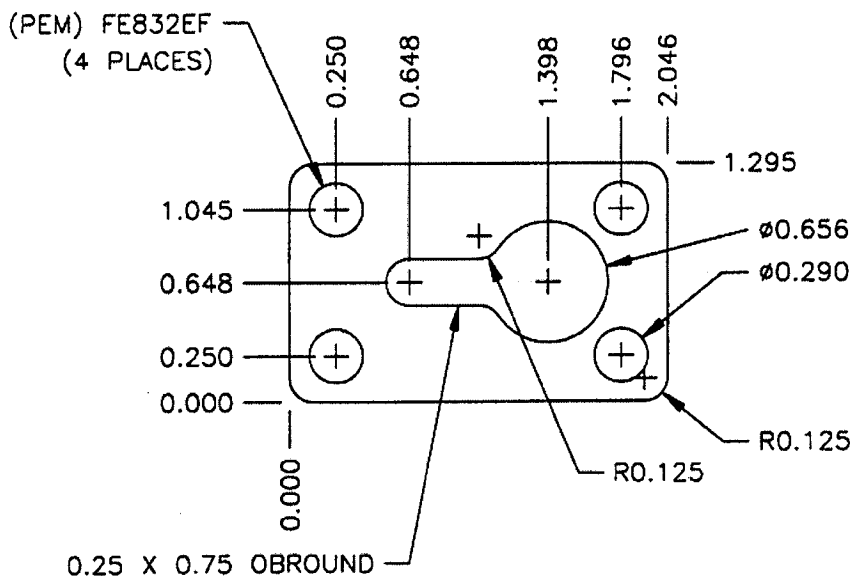
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.248	✓		Vern	
0.648	+/-0.010	0.651	✓		Vern	
1.796	+/-0.010	1.791	✓		Vern	
2.046	+/-0.010	2.052	✓		Vern	
1.295	+/-0.010	1.300	✓		Vern	
0.656	+0.005/-0.000	0.656	✓		Vern	
0.290	+0.005/-0.000	0.290	✓		Vern	
0.250	+/-0.010	0.252	✓		Vern	
0.250	+/-0.010	0.255	✓		Vern	
0.648	+/-0.010	0.650	✓		Vern	
1.045	+/-0.010	1.048	✓		Vern	

Measured by:	SAD	Audited by:	SE	Prototype Approval:	N/A
Date:	07/05/09	Date:	07.05.09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2348	SHEET 1 OF 1
DATE	TITLE	SCALE	
95:01:20	WEAR PLATE	1:1	
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II/IB CLASS 2
 - 3) INSTALL FE832 EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER PART QSF 01B UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31919

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~

TNM



ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / AS9100 certified
 approuvé NADCAP approved

C. OF C

55318

17-May-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY, ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

**PURCHASE ORDER/
 NO. DE COMMANDE:** 00003741



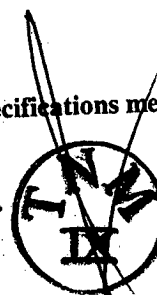
ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	53	53	D2348 B31919	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

counted 53

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
 Travel cards have been filed and are available for viewing upon request.



Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****55318**

17-May-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE: 00003741****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PRIX UNITAIRE UNIT PRICE	EXTENSION
1	53	53	D2348	B31919	\$3.60	\$190.80
SUB TOTAL:						\$190.80
TPS/GST:						\$11.45
TVQ/PST:						\$0.00
TOTAL AMOUNT DUE:						\$202.25

UNIT PRICE TO BE APPLIED

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

**CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the intrinsic value of the parts.